

Date: Wednesday, 3/14/2007 3:32:13 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG BRACKET
Job Number	: 31228		
Estimate Number	: 10733		
P.O. Number	: N/A	Part Number	: D30461
This Issue	: 3/14/2007 S.O. No. : N/A	Drawing Number	: D3046 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 3/14/2007 Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 31160	Material	: N/A
Written By	: <u>JD 07.03.15</u>	Due Date	: 3/30/2007
Checked & Approved By	: <u>JD 07.03.15</u>	Qty:	20 Um: Each
Comment	: Est A 01.08.27 New Issue SM		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M174S12GA

17-4 STAINLESS STEEL SHEET



Comment: Qty.: 0.1260 sf(s)/Unit Total : 2.5200 sf(s)

M174S12GA

Batch: m103905ml 07 04 19

(20)

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3046

Dwg Rev: BProg Rev: Bml 07 04 19

(20)

2-Deburr if necessary

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

ml 07 04 19

(20)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

JD 07/04/23

(20)

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Tumble & deburr

Bend as per dwg D3046

JB 07/04/23 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/04/24
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/14/2007 3:32:14 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG BRACKET

Job Number: 31228

Part Number: D30461

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2004.23

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: *N/A*

FC 07/04/23

(20)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(20)

Comment: FINAL INSPECTION/W/O RELEASE

2007/04/24

Job Completion



u 2004.24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector



Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

FIRST ARTICLE INSPECTION CHECKLIST

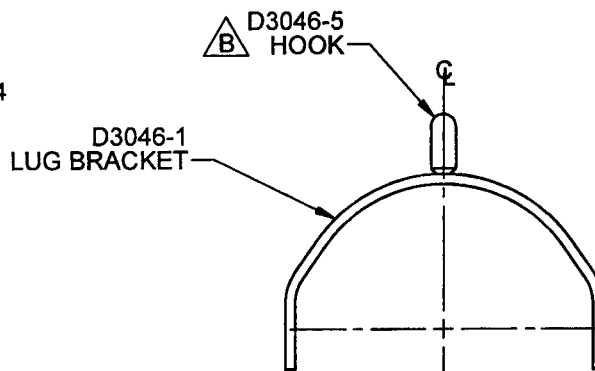
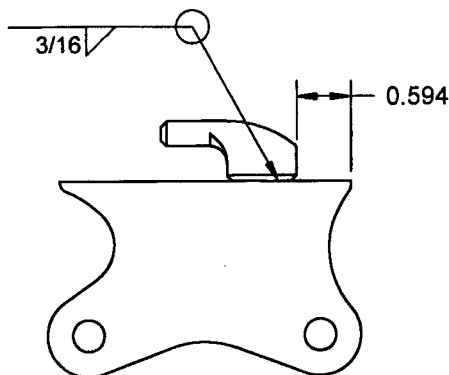
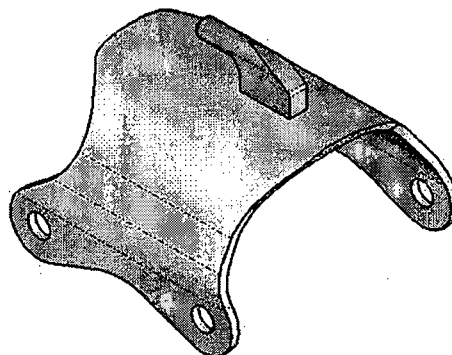
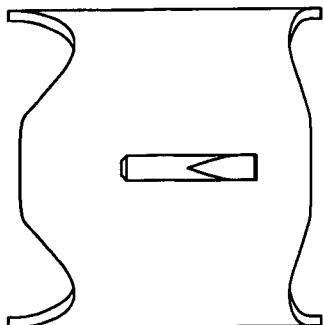
Rev	Date	Change	Revised by	Approved
A	06.09.27	New Issue	KJ/JLM 	



DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JH	APPROVED #	DRAWING NO. D3046	REV. B SHEET 1 OF 3
DATE 06.10.26	TITLE LUG BRACKET ASSEMBLY		SCALE 1:2
REV A	DATE 01.08.23	DESCRIPTION NEW ISSUE	
B	06.10.26	ADD D3046-5 REMOVE D3046-3; INCREASE HOLE DIAMETER OF D3046-1; CHANGE MATERIAL TO 17-4PH FROM 1010 STEEL	

RELEASED

06.11.13



D3046-041 LUG BRACKET ASSEMBLY

QTY	P/N	DESCRIPTION
X	D3046-041	GROUND HANDLING LUG ASSEMBLY
1	D3046-1	LUG BRACKET
1	D3046-5	HOOK

B

NOTES:

- 1) FINISH: HEAT TREAT ASSEMBLY TO H900 HARDENED CONDITION (MIN 190 KSI)
POWDER COAT ASSEMBLY WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) WELD PER DART QSI 004
- 5) PART IS SYMMETRICAL ABOUT C
- 6) IDENTIFY WITH P/N D3046-041 USING FINE POINT PERMANENT INK MARKER

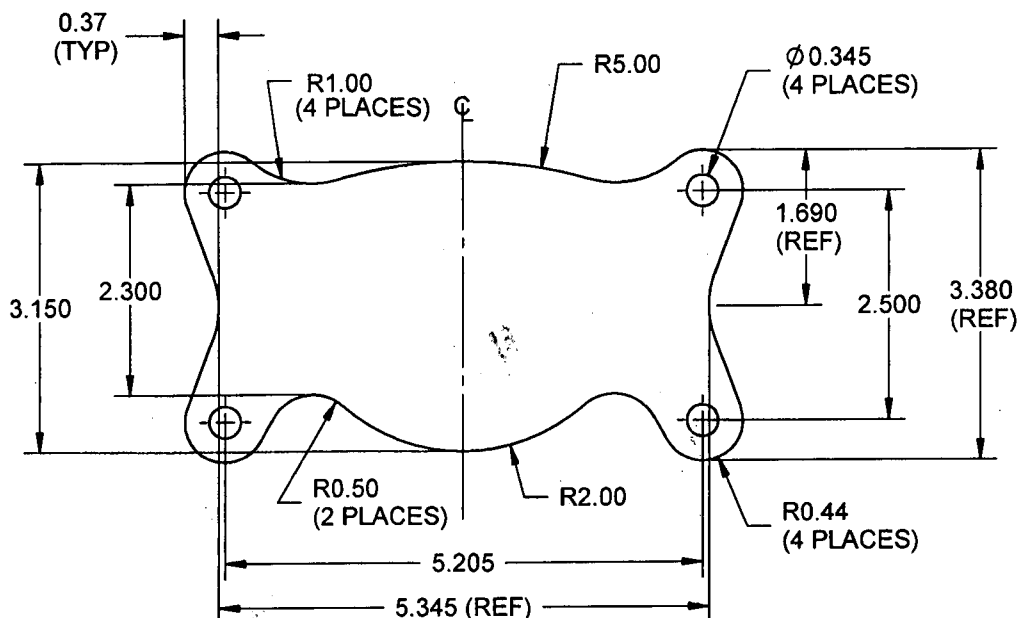
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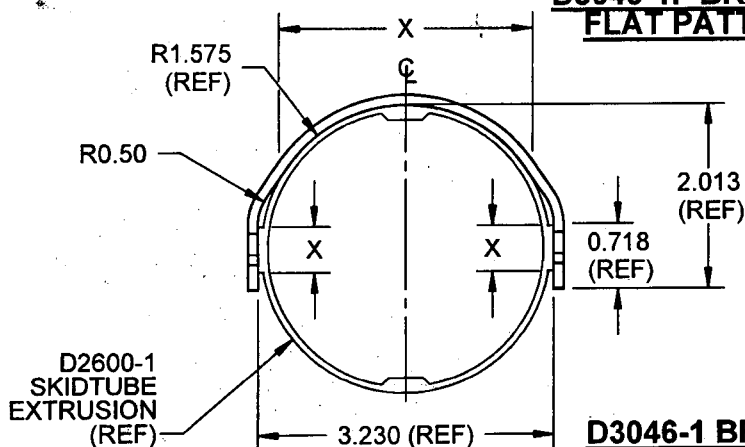
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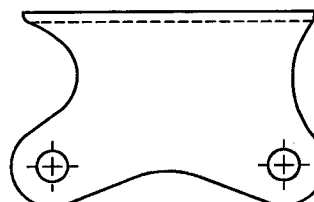
DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3046	REV. B SHEET 2 OF 3
DATE 06.10.26	TITLE LUG BRACKET ASSEMBLY		SCALE 1:2



**D3046-1F BRACKET
FLAT PATTERN**



**D3046-1 BRACKET
BEND DETAIL**

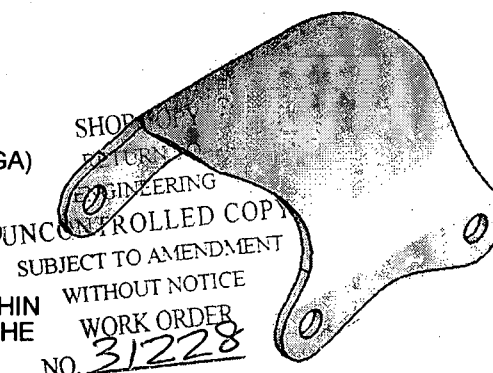


RELEASED

06/11/13

NOTES:

- 1) MATERIAL: 17-4PH STAINLESS STEEL SHEET, 0.109" THICK (12 GAUGE) PER AMS 5604 (REF DART SPEC M17-4-S12GA)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) D3046-1 SHOULD BE BENT USING DT8351 TOOL SO THAT IT IS WITHIN 0.010" OF THE OUTSIDE PROFILE OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X'.



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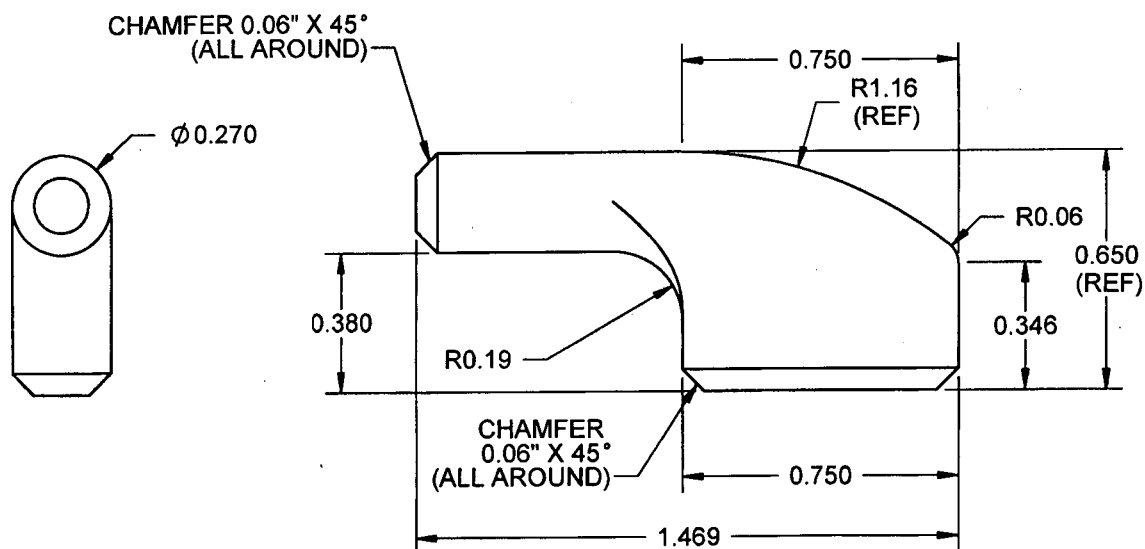
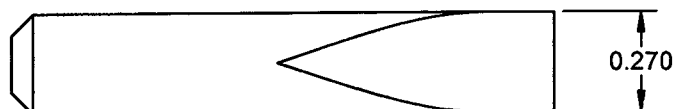
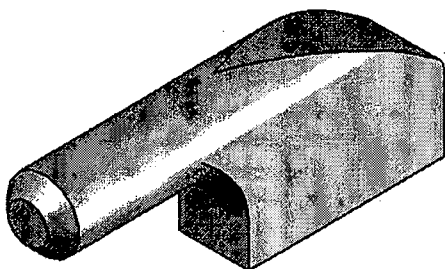
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DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED Jh	APPROVED Jh	DRAWING NO. D3046	REV. B SHEET 3 OF 3
DATE 06.10.26	TITLE LUG BRACKET ASSEMBLY		SCALE 2:1

RELEASED

06.11.13



D3046-5 HOOK

NOTES:

- 1) MATERIAL: 17-4PH STAINLESS STEEL BAR PER AMS 5604 OR AMS 5643 (REF DART SPEC. M17-4-B)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

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